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(54) **METHOD FOR STABILIZING STRIP DURING WINDING**

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See application file for complete search history.

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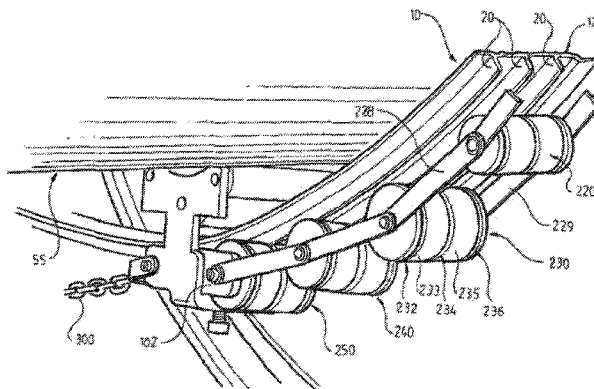
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(57) **ABSTRACT**

A method is disclosed for winding a composite strip onto a spool having a hub in which the strip includes a plurality of laterally spaced apart lengthwise extending rib portions upstanding from the base portion. The method comprises the steps of feeding the strip towards the hub of the spool; driving the fed strip through a roller set so as to plastically deform the strip to give it a curved base portion; and winding the deformed strip onto the hub to form spooled strip, the winding creating tension in the strip. The plastic deformation of the strip through the roller set substantially reduces the tension in the strip that would otherwise occur.

10 Claims, 18 Drawing Sheets



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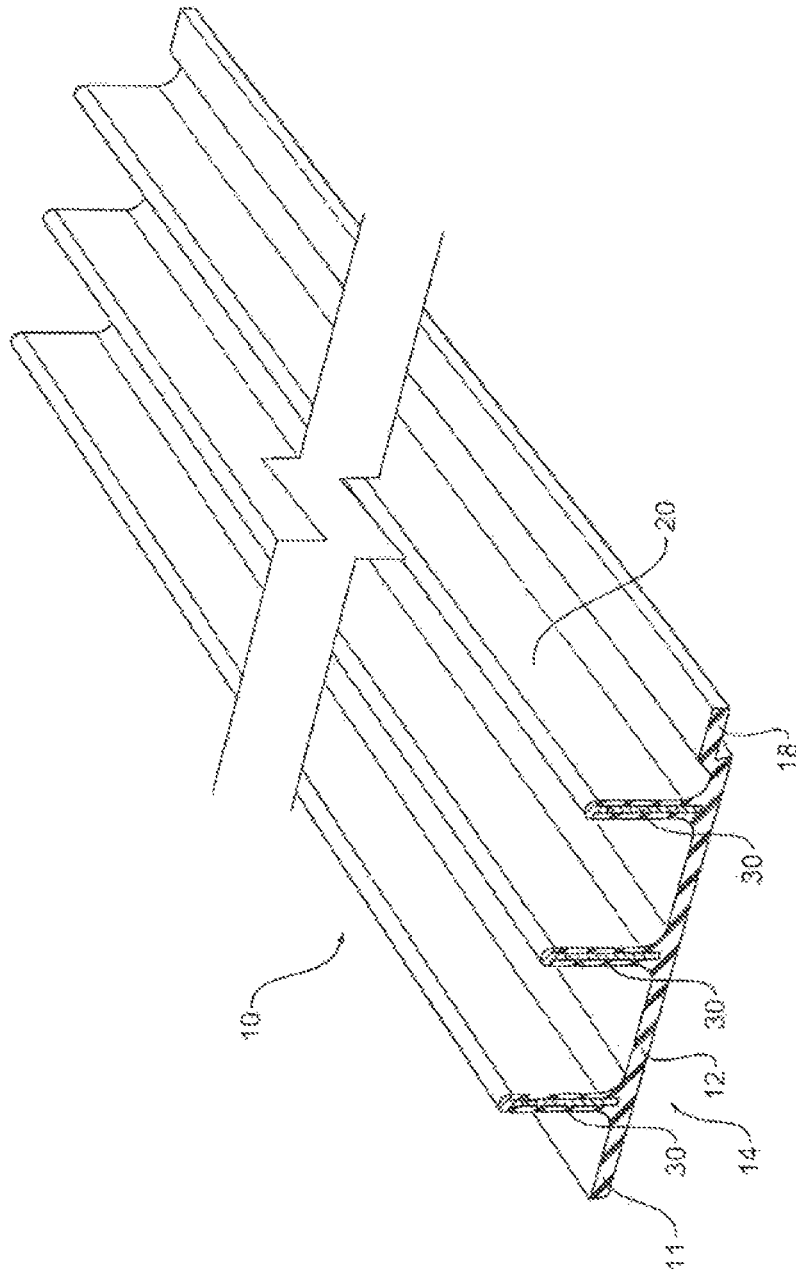


Fig 1
(Background Art)

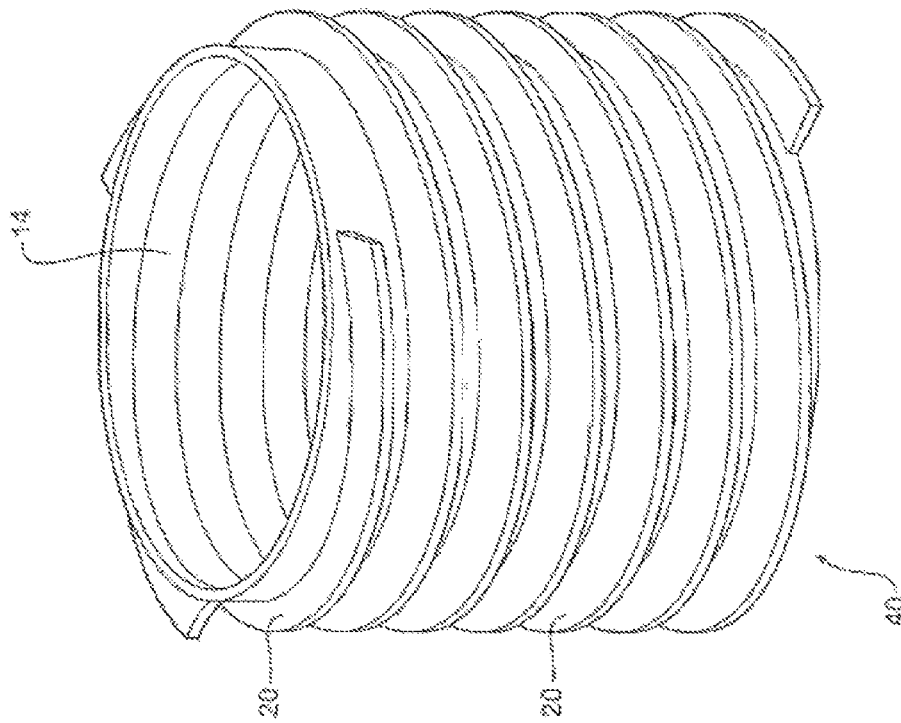


Fig 2a
(Background Art)

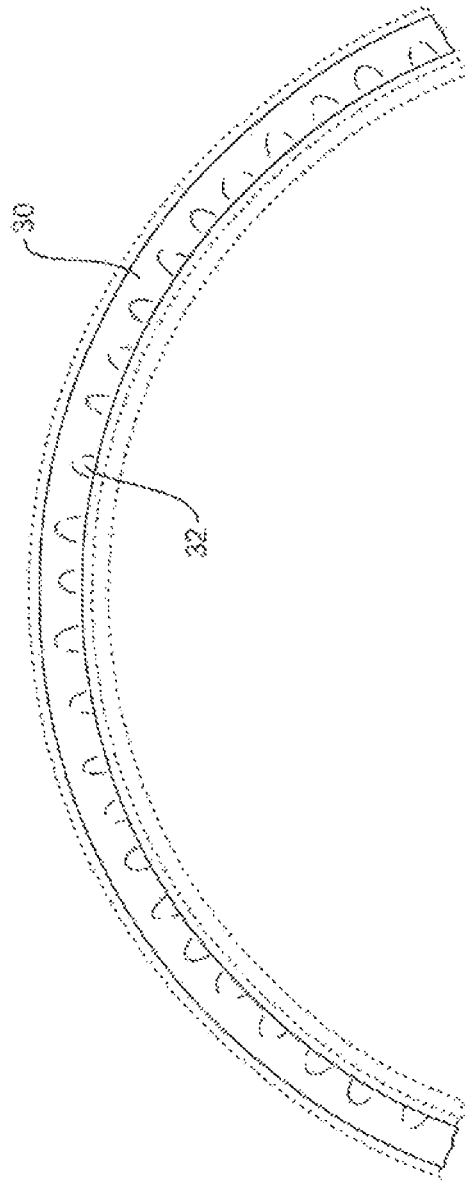
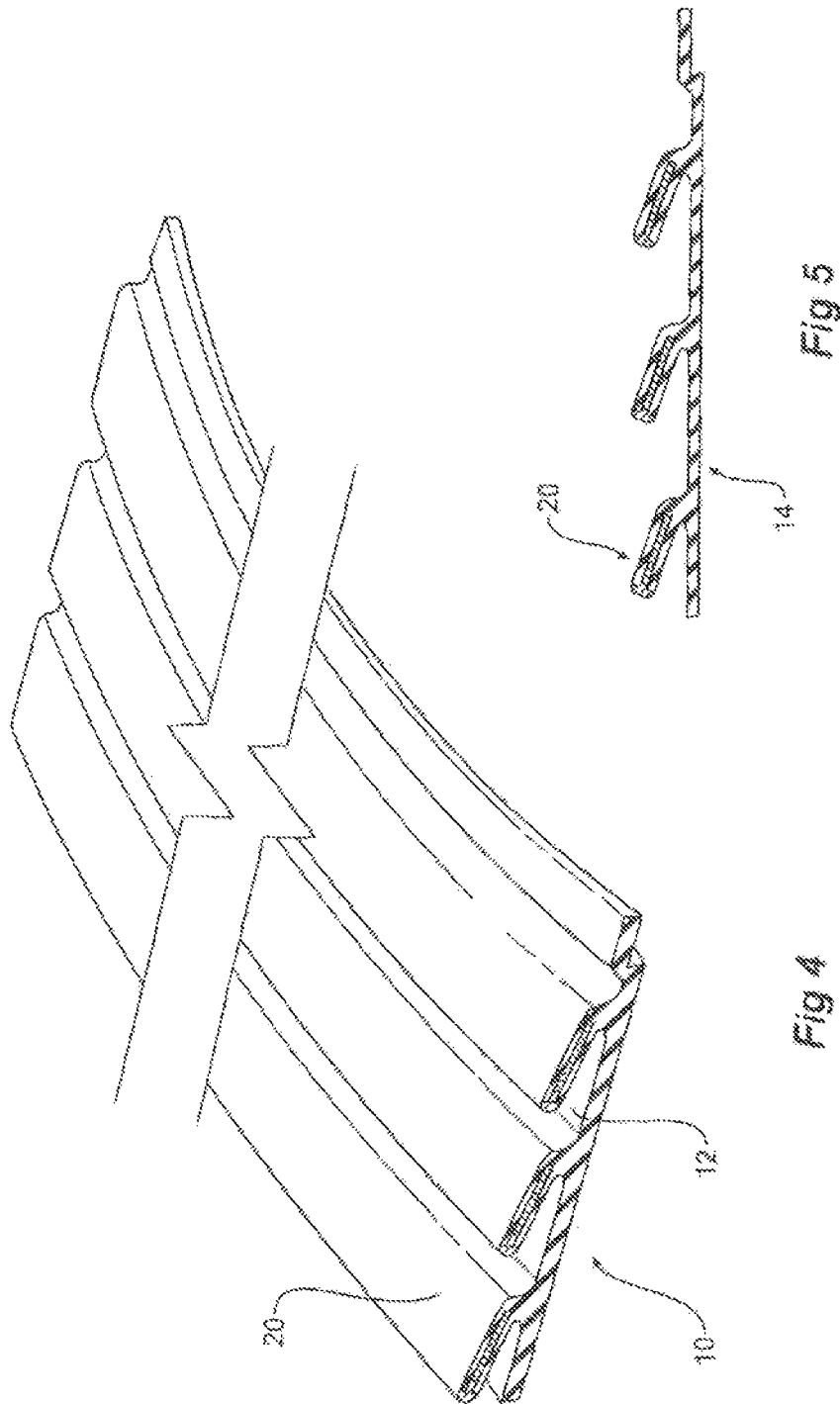


Fig 3
(Background Art)



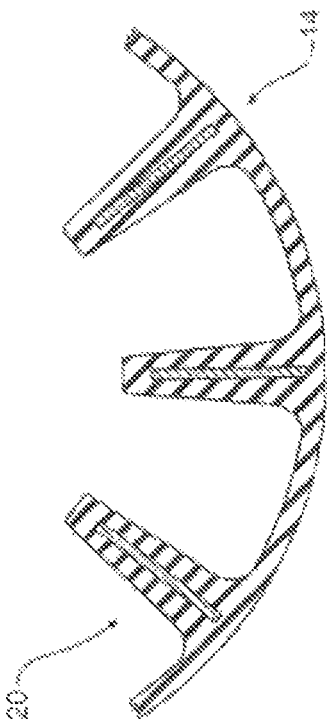


Fig 7

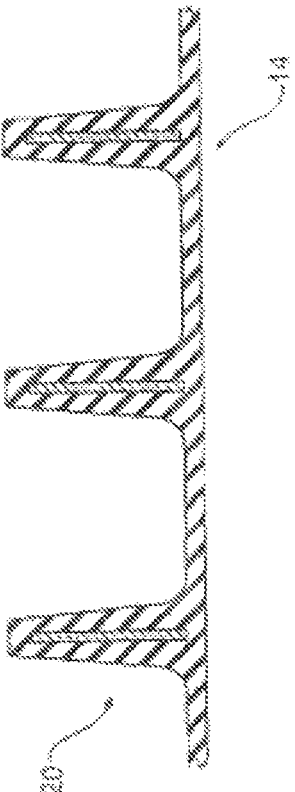


Fig 6

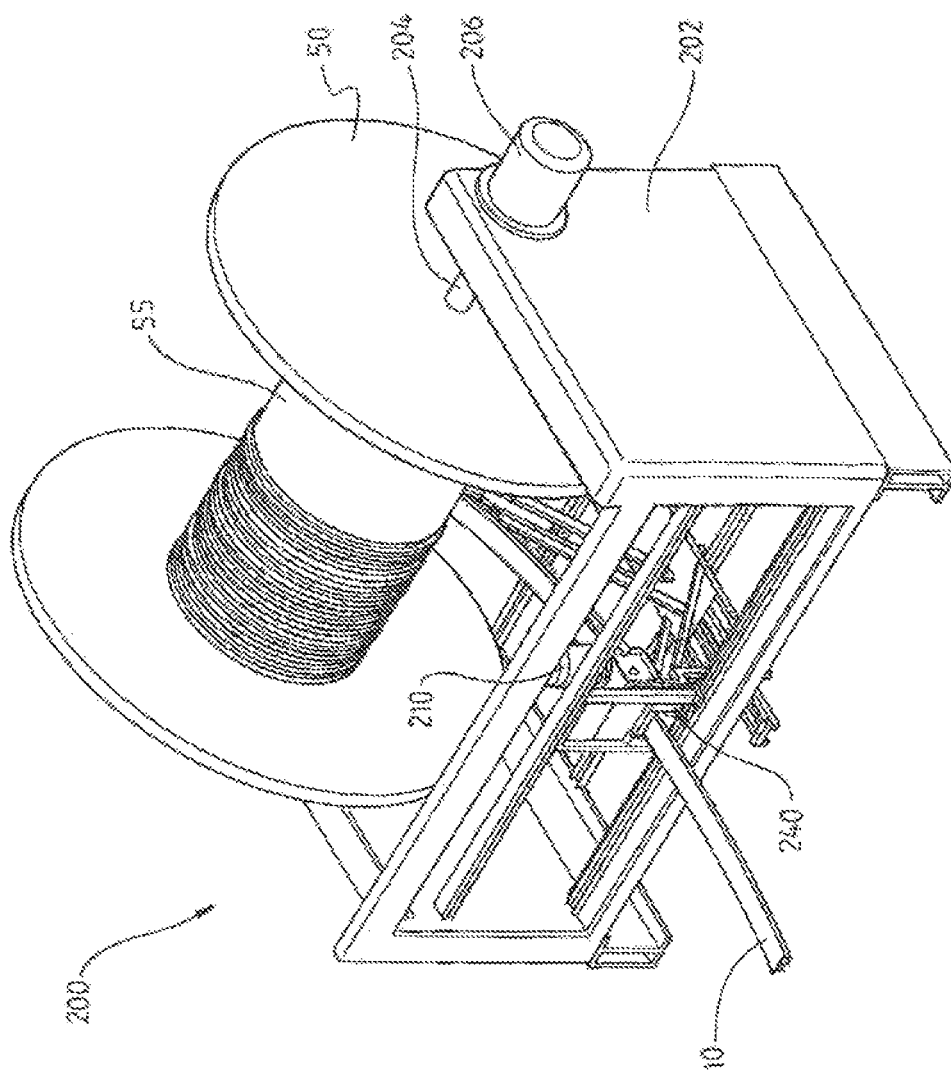
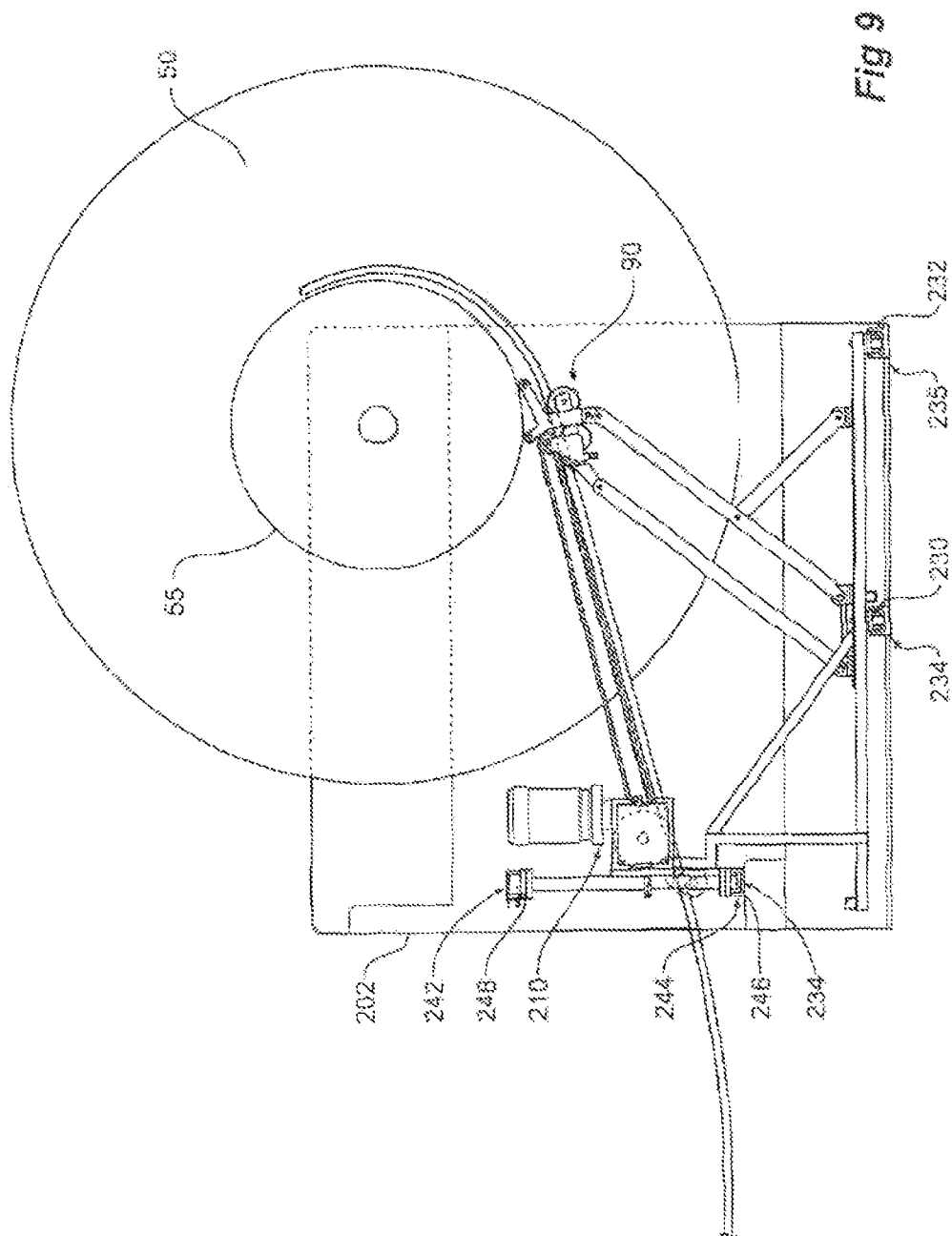
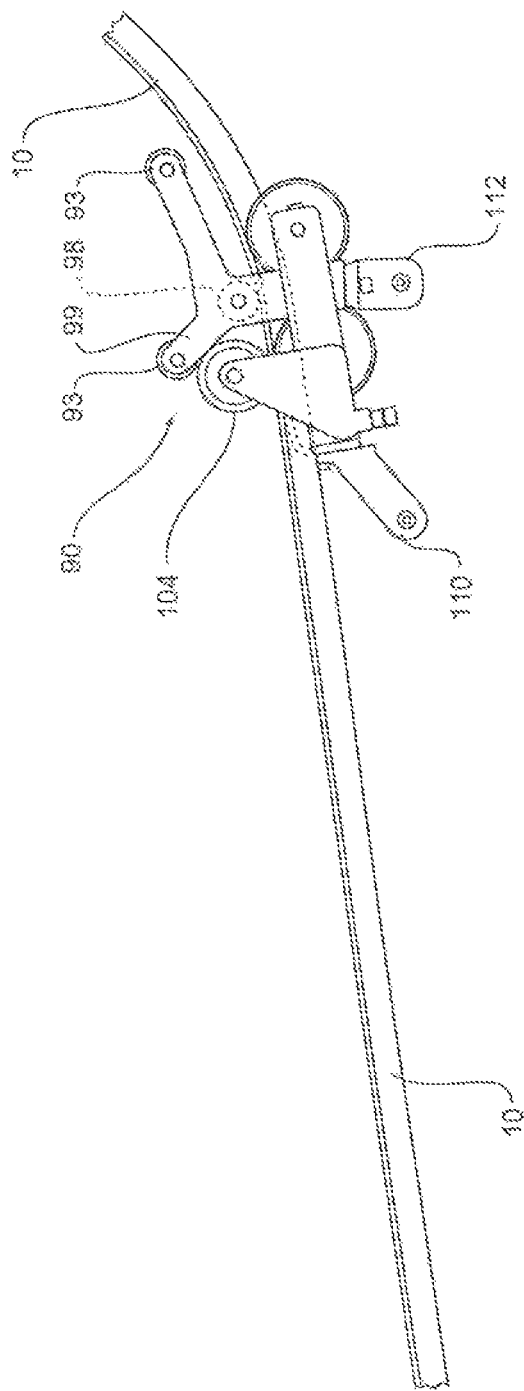


Fig 8





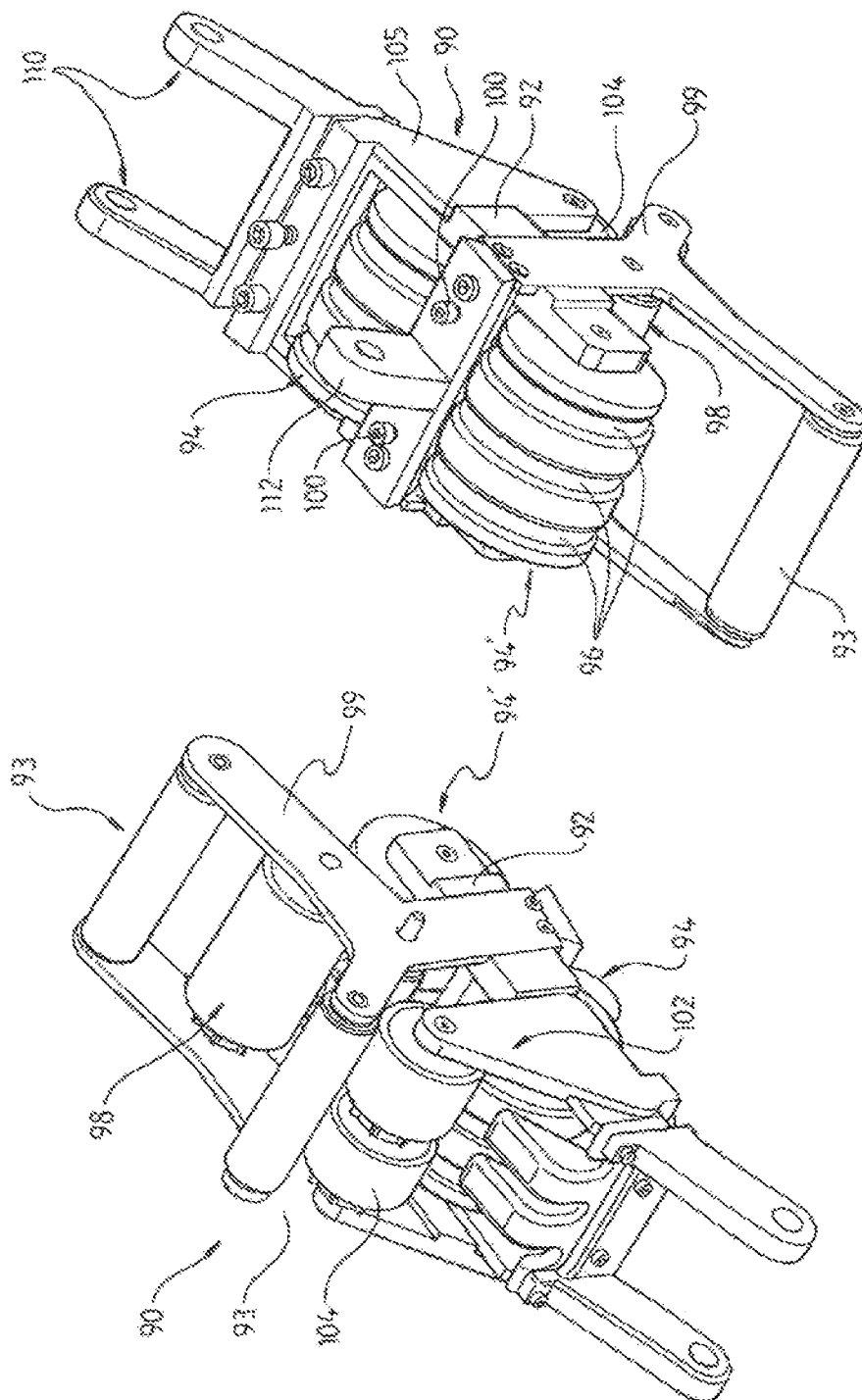


Fig 11b

Fig 11a

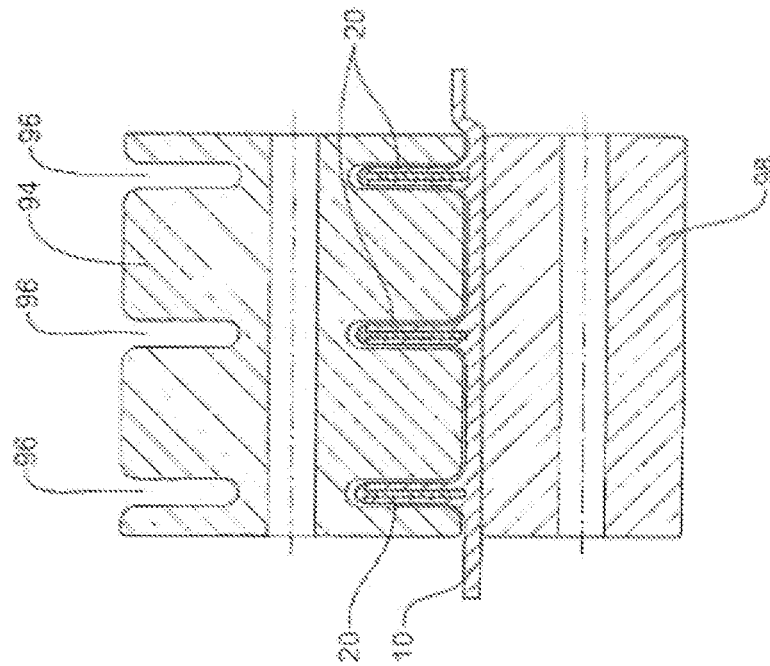
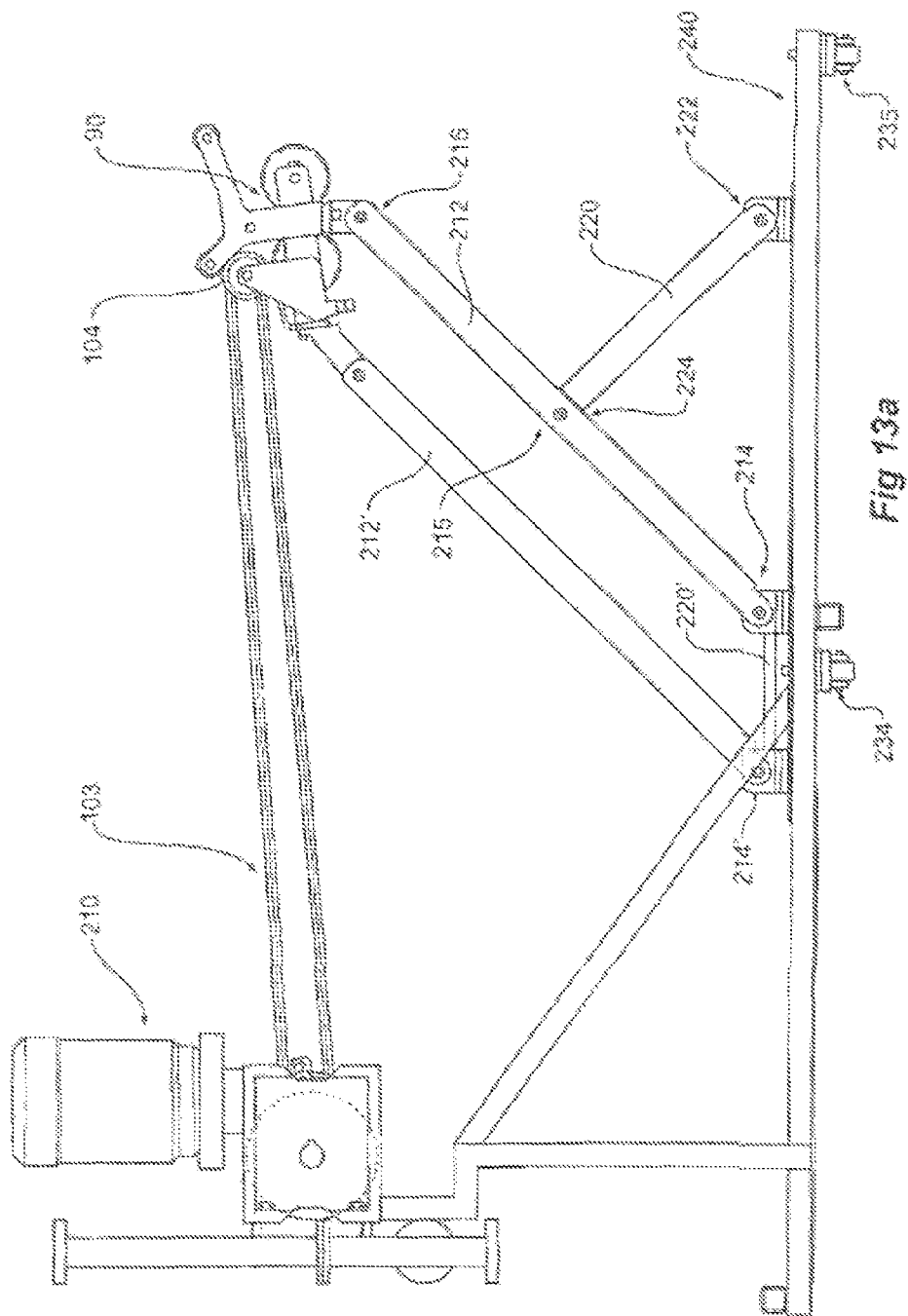
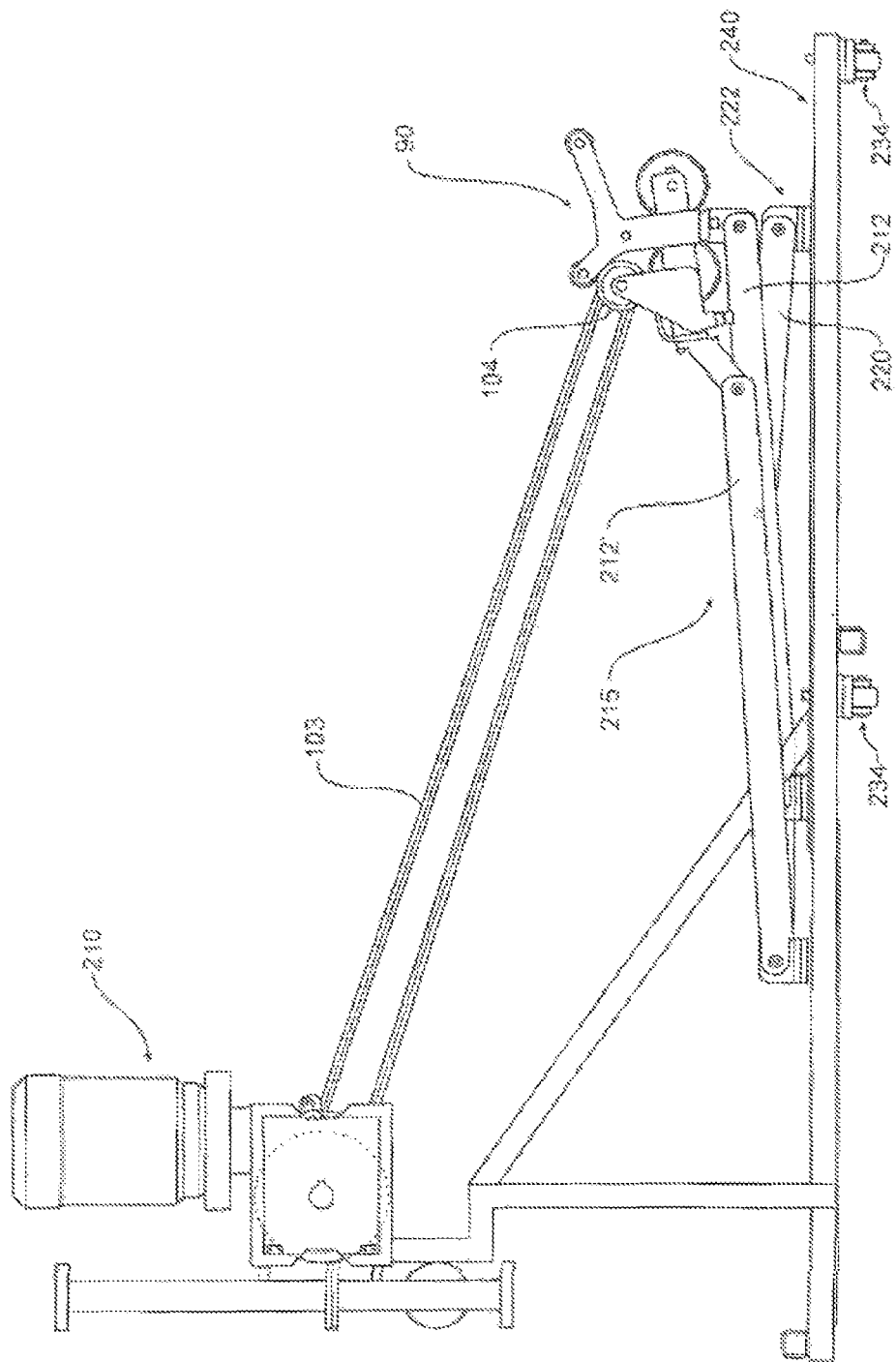


Fig 12



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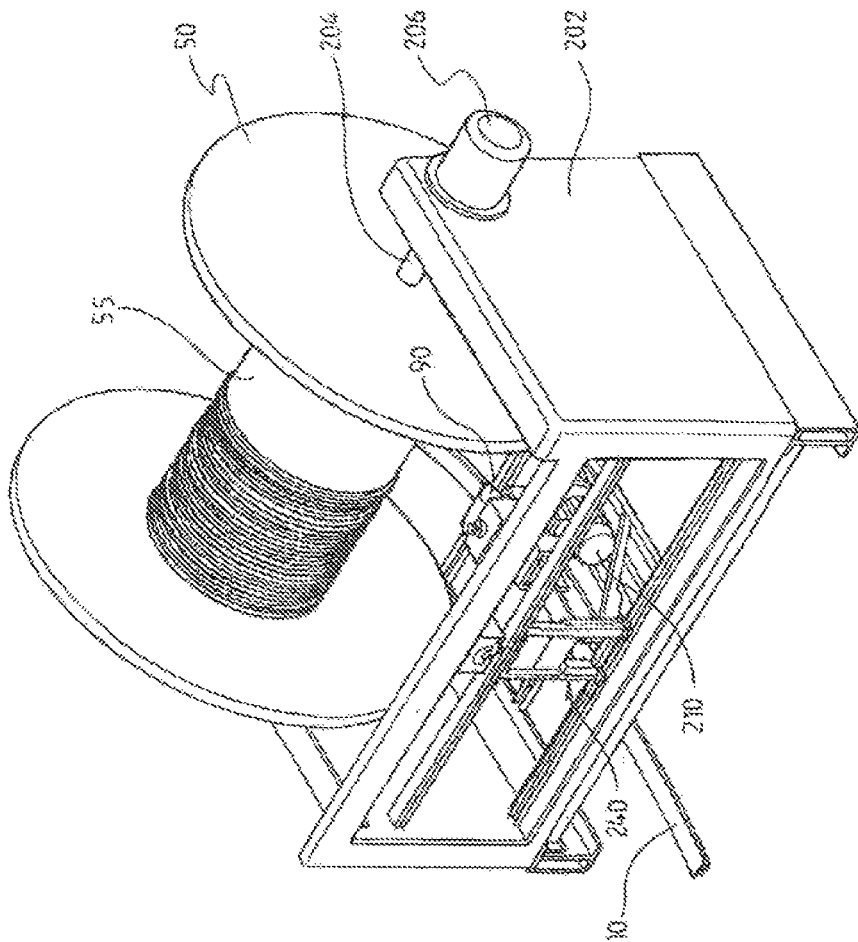


Fig 14

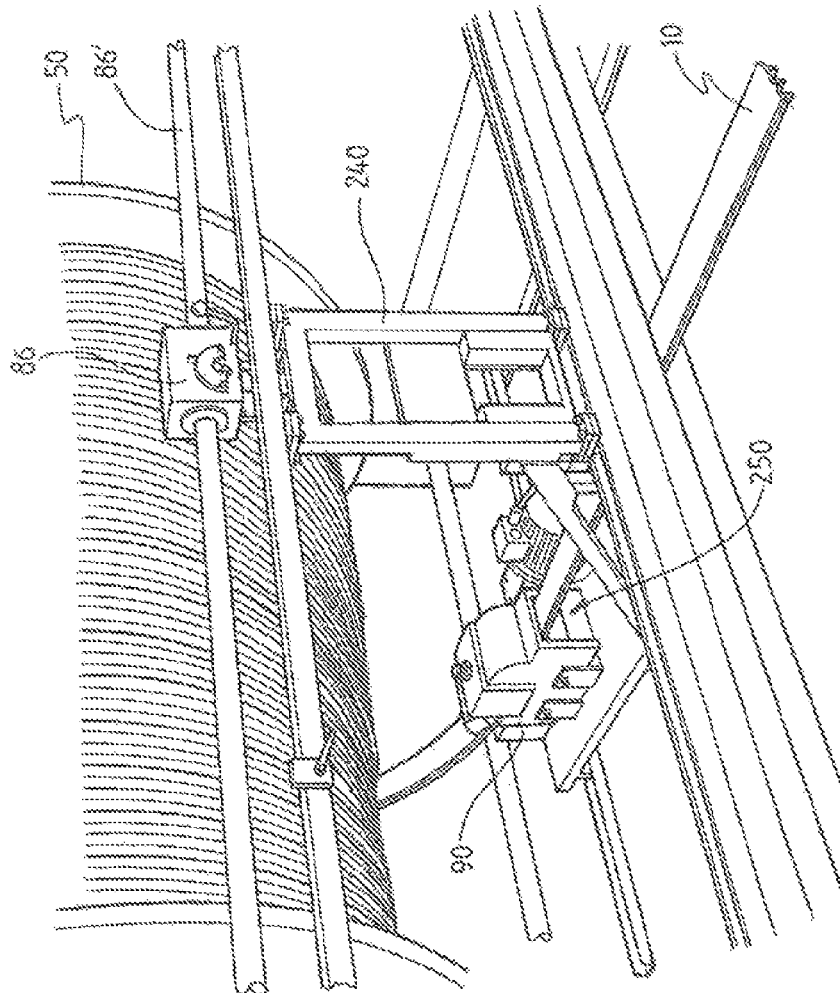
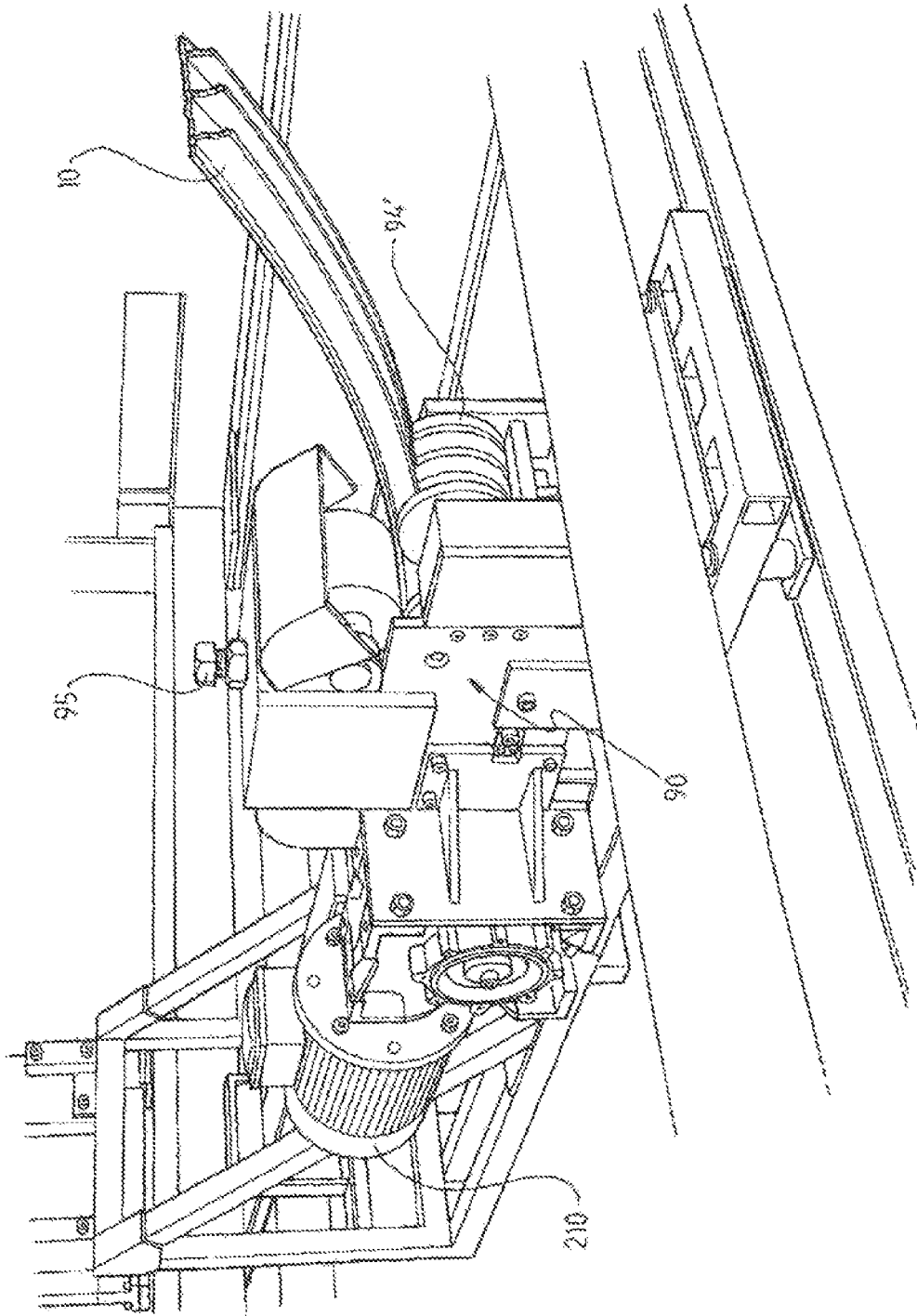


Fig 15



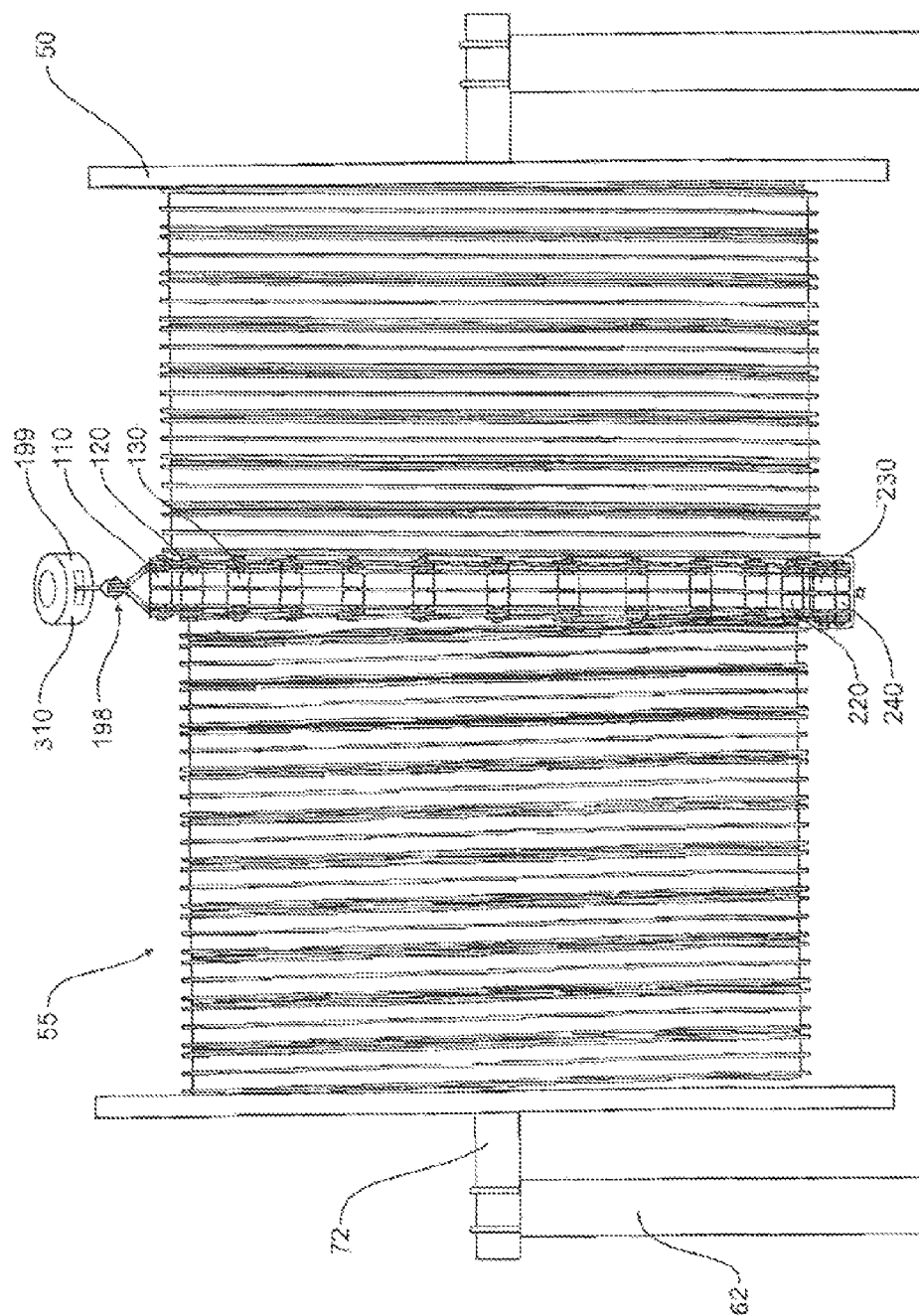


Fig 17

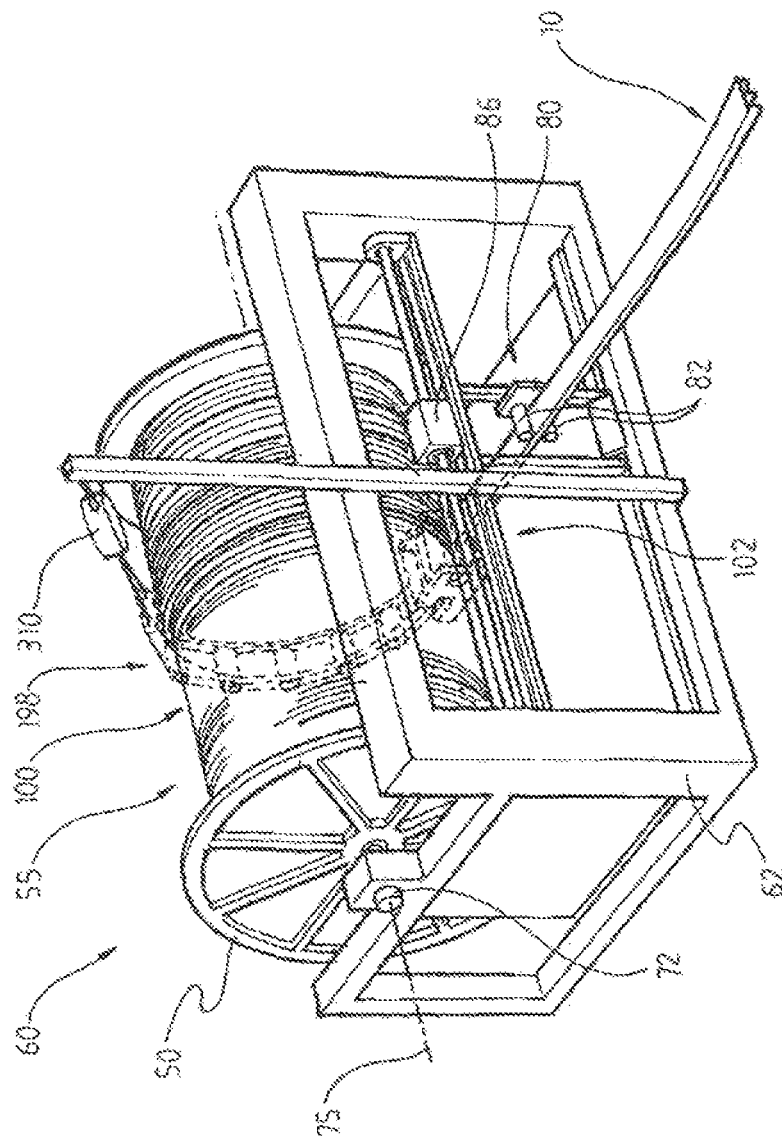
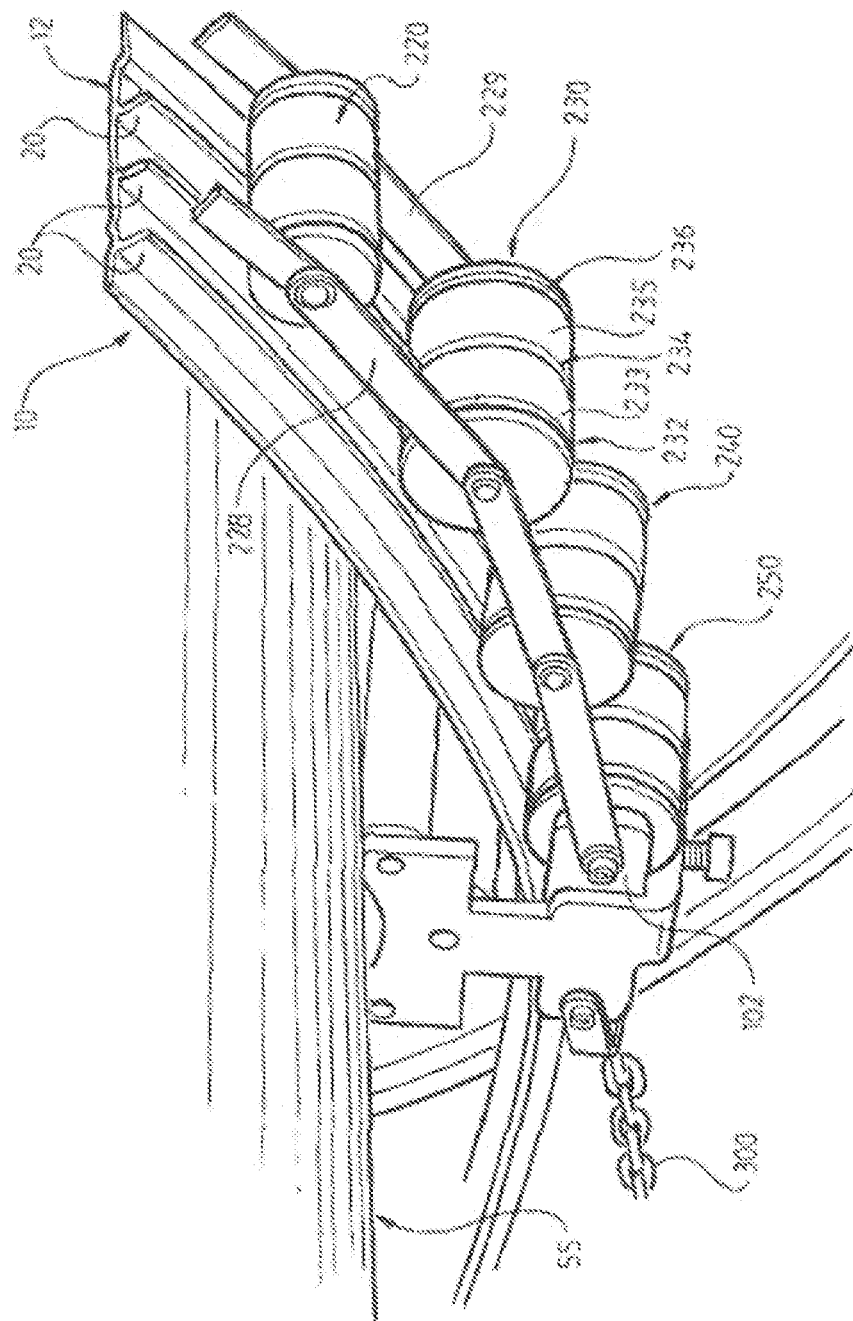


Fig 18



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METHOD FOR STABILIZING STRIP DURING WINDING

CROSS-REFERENCE TO RELATED APPLICATION

This application is a divisional of U.S. Ser. No. 11/716,458 filed on Mar. 9, 2007, now U.S. Pat. No. 8,052,412, which, in turn, claims priority to Australian application Serial No. AU2006901189 filed Mar. 9, 2006, both incorporated herein by reference.

FIELD OF THE INVENTION

The present invention relates to helically wound pipes and in particular to apparatus and methods for handling and spooling strips to be wound into helically wound pipes.

BACKGROUND

Plastic pipes can be made by helically winding a plastic strip having series of spaced apart upstanding ribs extending longitudinally. This form of helically wound tube or pipe is already known in the piping industry and is described in patents by the applicant relating both to the form of the plastic strip and to the form of the machine by means of which the pipes or tubes are produced from such strips.

In the past, in order to create high performance pipes it was necessary for the wall thickness of the plastic strip and its ribs to be quite substantial. However, the applicant's Australian Patent No. 2003227090 disclosed an important advance in helically wound pipes. The composite strip disclosed by Patent No. 2003227090 includes an elongate reinforcing strip extending lengthwise and supported laterally by a rib portion (see FIG. 1). The reinforcing strip has a height to thickness ratio of at least 3 to 1 and is orientated substantially perpendicular to the base of the strip. With this composite strip, a stiff pipe, able to withstand significant radial crushing forces can be produced without the need for a strip having a thick plastic base and thick ribs (see FIG. 2 for instance).

When a composite strip, such as the strip described in the applicant's Australian Patent No. 2003227090, or another functionally similar strip, is wound on to a spool for transport after manufacture, difficulties may be encountered. In particular, where the composite strip has been designed for a large diameter pipe, often it is desirable to wind the strip on to a spool having a hub with a diameter substantially less than that of the final wound pipe. It has been found that this can create problems relating to the stability of the reinforcing portion within the composite strip. More specifically, there can be a tendency for the ribs of the composite strip to collapse sideways towards the base as is shown in the background drawings of FIGS. 4, 5, 6 and 7.

Another problem with spooling composite strip of the type discussed above is that if conventional spooling methods and apparatus are used, the tension in the strip becomes so high that the strip is crushed or otherwise damaged in the spooling process.

It is an object of the present invention to provide an apparatus and method that address or at least ameliorates some or all of the afore-mentioned problems

SUMMARY OF THE INVENTION

According to a first aspect of the invention there is provided a spool winding assembly for winding a composite strip onto a spool having a hub, the composite strip including: an elongate

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gate plastic strip having a flat base portion and a plurality of laterally spaced apart lengthwise extending rib portions upstanding from the base portion; and a plurality of elongate reinforcing members extending lengthwise within respective rib portions, the rib portions and the reinforcing members forming composite ribs, the spool winding assembly including: a main frame, a spool holder for rotatably supporting the spool relative to the main frame, a spool drive unit for driving the spool with respect to the main frame, a carriage mounted for lateral movement with respect to the spool, a bender mounted to the carriage for receiving the strip as it is fed towards the hub of the spool and for deforming the strip to give it a curved base portion, and a bender drive unit operably connected to the bender for driving the strip through the bender. Preferably the bender includes: a bender frame, a pair of parallel spaced apart support rollers rotatably mounted to the bender frame, at least one of the support rollers defining grooves for receiving the composite ribs of the composite strip, and a set roller parallel to the support rollers, rotatably mounted to the bender frame and arranged to roll on an inner side of the composite strip, the inner side being a side of the base portion opposite the side from which the ribs extend, the set roller positioned or positionable such that as composite strip is driven between the support rollers and the set roller, the composite strip is deformed such that it exits the bender with a curved base portion.

Preferably the assembly further includes a composite strip having an elongate plastic strip having a flat base portion and a plurality of laterally spaced apart lengthwise extending rib portions upstanding from the base portion; and a plurality of elongate reinforcing members extending lengthwise within respective rib portions, the rib portions and the reinforcing members forming composite ribs, wherein the grooves of the support roller are shaped and sized complementary to the composite ribs such that as the composite strip is driven between the support rollers and the set roller, the composite ribs are held against any substantial lateral movement with respect to the base portion.

According to a second aspect of the invention there is provided a spool winding assembly for winding a composite strip onto a spool having a hub, the composite strip including: an elongate plastic strip having a flat base portion and a plurality of laterally spaced apart lengthwise extending rib portions upstanding from the base portion; and a plurality of elongate reinforcing members extending lengthwise within respective rib portions, the rib portions and the reinforcing members forming composite ribs, the spool winding assembly including: a main frame, a spool holder for rotatably supporting the spool relative to the main frame, a spool drive unit for driving the spool with respect to the main frame, a bender mounted under the spool for movement radially away from the hub as a spool of wound strip grows in diameter, the bender receiving the strip as it is fed towards the underside of the spool and plastically deforming the strip to give it a curved base portion while maintaining the reinforcing strips in a substantially perpendicular orientation with respect to the base portion, and a spool drive unit for driving the strip through the bender. Preferably the bender includes: a bender frame, a pair of parallel spaced apart support rollers rotatably mounted to the bender frame, at least one of the support rollers defining grooves for receiving the composite ribs of the composite strip, and a set roller parallel to the support rollers, rotatably mounted to the bender frame and arranged to roll on an inner side of the composite strip, the inner side being a side of the base portion opposite the side from which the ribs extend, the set roller positioned or positionable such that as composite strip is driven between the support rollers

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and the set roller, the composite strip is deformed such that it exits the bender with a curved base portion.

Preferably the assembly further includes a composite strip having an elongate plastic strip having a flat base portion and a plurality of laterally spaced apart lengthwise extending rib portions upstanding from the base portion; and a plurality of elongate reinforcing members extending lengthwise within respective rib portions, the rib portions and the reinforcing members forming composite ribs, wherein the grooves of the support roller are shaped and sized complementary to the composite ribs such that as the composite strip is driven between the support rollers and the set roller, the composite ribs are held against any substantial lateral movement with respect to the base portion.

Preferably the assembly further includes: a carriage mounted for lateral movement with respect to the spool, a pair of support arms, each support arm having a lower end slidably mounted to the carriage, an intermediate section and an upper end pivotally connected to the bender, and a first tie arm, the first tie arm having a lower end connected to the carriage and an upper end connected to the intermediate section of one of the support arms, wherein the support arms and the first tie arm allow the bender to move radially away from the hub as a spool of wound strip grows in diameter without rotating the bender with respect to the main frame.

Preferably the lower ends of the support arms are connected by a second tie arm so as to maintain their relative spacing.

According to a third aspect of the invention there is provided an apparatus for winding an elongate strip having a plurality of upstanding ribs onto a spool having a hub,

the apparatus including: a frame, a spool holder for rotatably supporting the spool relative to the frame, a guide assembly for guiding the strip generally tangentially towards the hub, the guide assembly movable relative to the spool in a direction parallel to an axis of spool rotation, a string of grooved rollers arranged so as to rotate about spaced apart parallel axes, each roller held in a spaced apart relationship from an adjacent roller by a pair of links, each pair of links pivotally movable with respect to an adjacent pair of links, the string extending partially around the hub and having first and second ends connected to the guide assembly for movement with the guide assembly relative to the spool, and a means for maintaining a substantially constant tension in the string as the spool is wound, wherein the rollers press the strip radially inwards towards the axis of the spool and the grooves surround the ribs of the strip as it is curved around the spool thereby supporting the ribs.

According to fourth aspect of the invention there is provided a method of winding a composite strip onto a spool having a hub, the strip having a plurality of laterally spaced apart lengthwise extending rib portions upstanding from the base portion, the method comprising the steps of: feeding the strip towards the hub of the spool, driving the fed strip through a roller set so as to plastically deform the strip to give it a curved base portion, and winding the deformed strip onto the hub to form spooled strip, the winding creating tension in the strip, wherein the plastic deformation of the strip through the roller set substantially reduces the tension in the strip that would otherwise occur. Preferably the rib portions are held upstanding from the base portion as they are driven through the roller set, whereby the orientation of the rib portions with respect to the base portion remains substantially unchanged. Preferably the method further comprises varying the axial position on the spool to which the strip is guided. Preferably the step of driving and deforming the strip to give it a curved

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base portion produces a radius of curvature of between 120% and 80% of a radius of the hub.

According to a fifth aspect of the invention there is provided a method of winding an elongate ribbed strip onto a spool having a hub, the method including the steps of: guiding the strip generally tangentially towards the hub, winding the strip around the hub, and supporting the ribs of the strip while the strip is bent around the hub. Preferably the method further comprises varying the axial position on the spool to which the strip is guided.

Specific embodiments of the invention will now be described in some further detail with reference to and as illustrated in the accompanying figures. These embodiments are illustrative, and are not meant to be restrictive of the scope of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

Preferred embodiments of the invention are illustrated in the accompanying representations in which:

FIG. 1 shows a composite strip windable into a helical pipe.

FIG. 2a shows a helical pipe wound from the strip of FIG. 1.

FIG. 3 shows a portion of the reinforcing strip within the pipe shown in FIG. 2.

FIG. 4 shows the strip of FIG. 1 with the ribs in a collapsed condition.

FIG. 5 is a cross-sectional view of the strip of FIG. 4.

FIG. 6 shows a further strip used on larger diameter pipes.

FIG. 7 is a cross-sectional view of the strip of FIG. 6 in a collapsed condition.

FIG. 8 is a perspective view of a spool winding assembly according to the invention.

FIG. 9 is a diagrammatic side view of the assembly of FIG. 8.

FIG. 10 is a side view of the bender of FIGS. 9 and 10 bending a strip.

FIGS. 11a and 11b are perspective views of the bender component of the spool winding assembly shown in FIG. 8.

FIG. 12 is a cross sectional view showing detail of a portion of the bender of FIGS. 11a and 11b.

FIGS. 13a and 13b are diagrammatic side views showing the bender of FIGS. 8 to 12 in a raised and lowered condition respectively.

FIG. 14 is a perspective view of a spool winding assembly according to a second aspect of the invention.

FIG. 15 is a close up underside perspective view of the assembly shown in FIG. 14.

FIG. 16 is a similar view to that of FIG. 15 but shows greater detail from the opposite underside.

FIG. 17 shows an apparatus according to a third aspect of the invention.

FIG. 18 shows the apparatus of FIG. 16 in perspective view.

FIG. 19 is a detailed partial underside perspective view of the apparatus shown in FIG. 18.

DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS OF THE INVENTION

Shown in FIGS. 1 through 7 is a composite strip that may be wound onto a spool with the present invention. Referring to FIG. 8, a spool winding assembly 200 that accords to a first aspect of the invention is shown. The spool winding assembly 200 is provided to wind a composite strip of the type shown in FIGS. 1 and 6 onto a spool. It comprises, a main frame 202, a spool holder 204 for rotatable supporting the spool 50 relative to the main frame, a spool drive unit 206, a bender 90 and a

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bender drive unit **210** for driving the strip **10** through the bender **90**. The bender **90** is mounted under the spool **50** for movement radially away from the hub **55** as a spool of wound strip grows in diameter. The bender **90** and its drive unit **210** are more clearly shown in FIGS. **9** and **10**. The bender **90** receives the strip **10** as it is fed towards the underside of the spool **50** and plastically deforms the strip **10** to give it a curved base portion while maintaining the reinforcing strips **30** (shown for instance in FIG. **1**) in a substantially perpendicular orientation with respect to the base portion **12**. In another embodiment of the invention (not shown) the bender **90** may be mounted over or adjacent the spool and strip **10** may be fed towards the top side of the hub **55** of the spool.

The bender **90** is more clearly shown in FIGS. **10**, **11a** and **11b**. Referring to these Figures, the bender **90** comprises a frame **92**, a pair of parallel spaced apart support rollers **94** and **94'** rotatably mounted to the bender frame **92**. As can be seen from FIG. **10**, both support rollers **94** and **94'** are shaped to define **3** grooves **96** for receiving the rib portions **20** of the strip **10** as is more clearly shown in FIG. **12**. A set roller **98** is arranged parallel to the support rollers **94** and is also rotatably mounted to the bender frame **92** by a set roller sub frame **99**. The set roller is arranged to roll on an inner side **14** of the composite strip **10**. The set roller **98** is positionable such that as the composite strip **10** is driven between the support rollers **94** and the set roller **98**, the reinforcing strips **30** within the composite strip **10** are plastically deformed such that the composite strip **10** exits the bender **90** with a curved base portion **12** while maintaining the reinforcing strips **30** in a substantially perpendicular orientation with respect to the base portion **12**. This is shown most clearly in FIG. **10**. A drive means **102** is provided for driving the strip **10** between the support rollers **94** and the set roller **98**.

In this embodiment of the invention, the drive means comprises a drive roller **104** that pinches the strip **10** between itself and a first support roller **94**. The drive roller **104** is itself driven by a chain **103** shown in FIGS. **13a** and **13b**, a bender drive unit **210** drives the chain **103** to cause the drive roller **104** to push the strip **10** between the set roller **98** and the second support roller. Commencement of bending the strip to be spooled is facilitated by the pushing action (a pulling arrangement would be difficult to start).

Referring to FIGS. **10**, **11** and **12**, it can be seen that the set roller **98** is mounted to a set roller sub-frame **99** (that is moveable relative to the support rollers **98**) to allow adjustments of the curvature imparted to the composite strip **10**. Adjustment bolts **100** are provided for this purpose. It has been found that for optimum spool winding, the degree of curvature imparted by the bender **90** should be similar to the curvature of the hub **55**. By approximately matching the radius of the wound strip to the radius of the hub **55**, the strip **10** spools readily with a very low tendency to collapse the ribs. As the spool diameter grows, it has been found that it is not necessary to adjust the degree of bending imparted by the bender **90**. While some degree of over bending occurs, this does not cause any significant difficulties.

An important element of the spool winding assembly of this embodiment is its ability to keep the bender **90** radially adjacent to the previous convolutions of the spooled strip as the spool grows in diameter. This is achieved by providing a mechanism to move the bender **90** radially away from the hub **55** as the spool of wound strip grows in diameter. This mechanism includes a carriage **240** mounted for laterally movement with respect to the spool **50**, a pair of support arms **212** and **212'** and a pair of tie arms **220** and **220'** as is most clearly shown in FIGS. **13a** and **13b**. Referring to FIG. **13a**, it can be seen that support arm **212** has a lower end **214** that is slidably

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mounted to the carriage **240** and an upper end **216** which is pivotally connected to the bender **90** at a rear mount **112** on the bender (the rear mount is most clearly shown in FIG. **10**). A first tie arm **220** has a lower end **222** that is pivotally mounted to the carriage **240** and an upper **224** that is pivotally mounted to an intermediate section **215** of the support arm **212**. Further, a second tie arm **220'** links the lower end **214** of a first support arm **212** to a lower arm **214'** of second support arm **212'**. This arrangement allows the bender **90** to move substantially vertically up and down so that it can remain close to the spool as the spool is wound. Tracking rollers **93**, most clearly seen in FIG. **10**, roll against the hub **55** and then the actual spool of wound strip as spooling progresses.

In another embodiment of the invention, not shown, tie arm **220'** may be arranged in a similar fashion to tie arm **220**, that is it may be pivotally mounted to the carriage **240** at one end and pivotally mounted to an intermediate portion of the second support arm **212'** at its other end.

The carriage assembly **240** includes front underside rollers **234** and rear underside rollers **235** most clearly shown in FIGS. **13a** and **13b**. These rollers run in front and rear underside channels **230** and **232** shown in FIG. **9**. Upper and lower channels **242** and **244** also mounted to the main frame **202**. Guide rollers **246** and **248** are also mounted to the carriage **240**. This arrangement of rollers and channels allows the carriage **240** to move laterally with respect to the hub **55**.

Various drive means can be employed for driving the carriage **240** laterally across the hub as the strip is being wound. For instance, an endless pneumatic cylinder such as that shown in FIG. **15** can be used. A control system is employed to ensure that the carriage moves laterally back and forth across the hub in such a way that the strip is wound in radially distinct layers.

Operation of the spool winding assembly **200** will now be described with reference to the FIGS. **8** to **13a** and **13b**. Strip **10** is fed through carriage mouth **250**, (which ideally includes a plurality of rollers) across to the bender **90** and onto the spool **50**. The strip **10** is fed towards the spool **50** and is then driven through the roller set comprising support rollers **94** and set roller **98** and drive roller **104** so as to plastically deform the strip **10** to curve the base portion **12** while maintaining the reinforcing strips **30** in a substantially perpendicular orientation with respect to the base portion **12**. The now deformed strip **10** is wound onto the hub **55** to form spooled strip. As the spooled strip grows in diameter, the position of the roller set varies so as to maintain its position radially adjacent of the previous convolutions of the spooled strip.

A spool winding assembly according to a second embodiment of the invention is shown in FIGS. **14**, **15** and **16**. This embodiment of the invention is similar to the embodiment of the invention described above but the bender **90** travels only transversely with respect to the spool. It does not travel radially into towards and away from the hub. FIG. **15** in particular shows a friction box **86** mounted to a rod **86'** that drives the carriage **240** laterally back and forth from one side of the spool **50** to the other.

FIG. **16** shows the bender unit **90** in more detail. The bender **90** is similar to the bender shown in FIGS. **11** and **12** without the tracking rollers **93**.

The bender **90** plastically deforms the strip **10** and the spool drive unit **206** rotates the spool **50** with respect to the main frame to spool the strip **10** after it has been plastically deformed in the bender **90**. With this arrangement, the plastic deformation of the strip **10** by the bender **90** substantially reduces the tension in the strip **10** that would be required to wrap the strip **10** around the spool **50**. This is important for a number of reasons. One reason is that it enables control of the

tension in the strip wound around the hub to be varied independently of the primary bending process. By reducing the tension in the strip around the hub, the tendency to compress and collapse earlier wound convolutions of the strip is reduced.

With this embodiment of the invention, it has been found that for optimum spool winding, the degree of curvature imparted by the bender **90** should be similar to, or slightly less than, the curvature of the hub **55**. By approximately matching the radius of the wound strip to the radius of the fully wound spool (which will be greater than the radius of the hub **55**) the strip **10** spools readily with a very low tendency to collapse the ribs. While some degree of unsupported bending occurs after the strip passes through the bender **90**, this bending on the spool **50** does not cause any significant difficulties.

With this embodiment of the invention, it has been found that spools having a hub size approximately equal to the diameter required in the final wound pipe to be most appropriate.

Referring to FIGS. **17**, **18** and **19**, an alternative apparatus **60** for winding an elongate ribbed strip **10** onto a spool **50** is shown. The apparatus **60**, which accords to a third embodiment of the invention, includes a frame **62**, a spool holder in the form of a shaft **72**, a guide assembly **80** for guiding the strip generally tangentially towards the hub **55** as is best shown in FIG. **18**. The apparatus **60** also includes a string **100** of grooved rollers **110**, **120**, **130**, **140**, **150**, **160**, **170**, **180**, **190**, **200**, **210**, **220**, **230**, **240**, **250**. The grooved rollers are arranged to rotate about spaced apart parallel axes, each roller held in a spaced apart relationship from an adjacent roller by a pair of links, such as the links **228** and **229** between rollers **220** and **230** shown in FIG. **18**. Each pair of links is pivotally movable with respect to an adjacent pair of links. The string of rollers **100** extends around the hub **55** and has a first end **102** and a second end **198** connected to the guide assembly **80** for movement with the guide assembly relative to the spool **50** as is most clearly shown in FIG. **18**.

A means for maintaining a substantially constant tension in the string **100** as the spool **50** is wound is provided in the form of a cable tensioner **310** as shown in FIG. **18**. The cable tensioner **310** retracts or extends cable while maintaining the substantially constant tension. Referring to FIG. **19** it can be seen that roller **230** has three spaced apart grooves **232**, **234** and **236**. The spacing between the centre line of the grooves matches the spacing between the centre line of the ribs **20** of the strip **10** as is most clearly shown in FIG. **19**. Each of the rollers **110** to **250** within the string of rollers **100** has similar grooves to the grooves **232**, **234** and **236** shown in FIG. **19**. In use, the rollers press the strip **10** radially inwards towards the axis **75** of the spool **50** and the grooves surround the ribs **20** of the strip **10** as it is curved around the spool thereby supporting the ribs **20**.

The rollers and their grooves are sized such that there is some clearance between the apex of the ribs and the rollers at the bottom of the grooves as shown in FIG. **12**. This allows the cylindrical portions of the rollers, such as portions **233** and **235** of roller **230**, to press against the base portion **12** of the strip **10**. The pressure exerted by the rollers against the base portion **12** of the strip depends on the tension provided by the tensioning means **310**.

In this embodiment of the invention, a clearance of approximately 1 mm is provided between the rollers and the ribs **20**. In other applications other clearances may be used.

In use, the strip guide **80** traverses across the face of the hub **55** driven by a friction box or any other means **86** as illustrated in FIG. **18**. A control system is provided to ensure that the hub **55** is wrapped evenly with the strip **10**.

With all of the embodiments of the invention described above, the strip guide assembly **80** can be fixed to the frame **62** and the spool holder that rotatably supports the spool **50** relative to the frame **62** can be arranged to move laterally with respect to the frame **62**. This has the advantage of keeping the strip **10** travelling in a straight line without laterally bending while it is wound onto the spool **50**.

While the present embodiments have been described in terms of preferred embodiments in order to facilitate better understanding of the invention, it should be appreciated that various modifications can be made without departing from the principles of the invention. Therefore, the invention should be understood to include all such modifications within its scope.

We claim:

1. A method of winding a composite strip onto a spool having a hub, the strip having a plurality of laterally spaced apart lengthwise extending rib portions upstanding from a base portion and reinforcing members extending lengthwise within respective rib portions, the method comprising the steps of:

feeding the strip towards the hub of the spool;

driving the composite strip through a bender including support rollers that define spaced apart grooves for receiving the rib portions of the strip in complementary relationship thereto, and a set roller;

supporting the rib portions of the strip within the grooves as the strip is driven through the bender thereby preventing rib collapse; the set roller being positioned such that, as the composite strip is driven between the support rollers and the set roller, the base portion of the composite strip is plastically deformed and the composite strip exits the bender with a curved base portion, while the reinforced rib portions of the strip are maintained in a substantially perpendicular orientation with respect to the base portion by the grooves; and

winding the deformed strip onto the hub while laterally varying relative positions of the bender back and forth across the hub with respect to the spool to ensure that the composite strip is wound in radially distinct layers around the hub to form a spooled strip wherein a degree of an imported curvature by the bender is adjusted to match a curvature of the hub.

2. The method as claimed in claim 1 wherein the step of driving the strip to impart a curvature to the base portion thereof produces a radius of curvature of between 120% and 80% of a radius of the hub.

3. The method of claim 1 wherein the driving step precedes the supporting step.

4. The method of claim 1 wherein the bender is mounted to a carriage and the carriage is moved laterally back and forth with respect to the spool to aid in laying the strip in radially distinct layers on the hub.

5. The method of claim 1 wherein the spool is mounted in a spool holder adapted to move the spool laterally, the bender includes a strip guide mounted to a frame, and the spool holder moves the spool laterally back and forth with respect to the frame to aid in laying the strip in radially distinct layers on the hub.

6. A method of winding a composite strip onto a spool having a hub, the strip having a plurality of laterally spaced apart lengthwise extending rib portions upstanding from a base portion and reinforcing members extending lengthwise

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within respective rib portions, the method comprising the steps of:

feeding the strip towards the hub of the spool;

driving the composite strip through a bender including support rollers that define spaced apart grooves for receiving the rib portions of the strip in complementary relationship thereto, and a set roller;

supporting the rib portions of the strip within the grooves as the strip is driven through the bender thereby preventing rib collapse; the set roller being positioned such that, as the composite strip is driven between the support rollers and the set roller, the base portion of the composite strip is plastically deformed and the composite strip exits the bender with a curved base portion, while the reinforced rib portions of the strip are maintained in a substantially perpendicular orientation with respect to the base portion by the grooves; and

winding the deformed strip onto the hub while laterally varying relative positions of the bender back and forth across the hub with respect to the spool to ensure that the composite strip is wound in radially distinct layers around the hub to form a spooled strip, and wherein the

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bender is moved radially away from the hub as successive layers of the strip are wound onto the hub wherein a degree of an imparted curvature by the bender is adjusted to match a curvature of the hub.

7. The method as claimed in claim 6 wherein the step of driving the strip to impart a curvature to the base portion thereof produces a radius of curvature of between 120% and 80% of a radius of the hub.

8. The method of claim 6 wherein the driving step precedes the supporting step.

9. The method of claim 6 wherein the bender is mounted to a carriage and the carriage is moved laterally back and forth with respect to the spool to aid in laying the strip in radially distinct layers on the hub.

10. The method of claim 6 wherein the spool is mounted in a spool holder adapted to move the spool laterally, the bender includes a strip guide mounted to a frame, and the spool holder moves the spool laterally back and forth with respect to the frame to aid in laying the strip in radially distinct layers on the hub.

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